

Date: Thursday, 29/06/2006 9:11:10 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 3.540" SKID TUBE "I" BEAM
Job Number : 27775	
Estimate Number : 12466	
P.O. Number : N/A	Part Number : D2963125
This Issue : 29/06/2006 S.O. No. : N/A	Drawing Number : D2963 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 06/07/2006 Qty: 14 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:A New Issue 06-06-20 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING

**Comment:** PURCHASINGIssue P/O: 200

a) Extrude as per Dwg D2963

b) Material: 6061-T6 (QQ-A-200/8)

c) Minimum tensile yield strength = 35 ksi

d) Minimum ultimate tensile strength = 40 ksi

e) Minimum elongation = 8%

f) Pull test required

u 29/05/06

2.0

D2963125P

105 I Beam Extrusion

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 14.0000 Each(s)

105 I Beam Extrusion

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** Ensure Certification and tests are attached

206/7/6 (14)

4.0

QC6

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

Inspect dimensions per Dwg D2963

Check Pull test per Dwg D2963 for compliance page attached.

Check hardness with Webster tester

206-07-07 (14)

Date: Thursday, 29/06/2006 9:11:11 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3.540" SKID TUBE "I" BEAM

Job Number: 27775

Part Number: D2963125

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

U 86-07-07

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/07/07 14

Job Completion



500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

06/12/06	141084	22371	1
Cust PO	B/I No	Lot	Date
00001200	00307305	22371020	6/12/06

Sold To	46024	Ship To	46024
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7		DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	

Item No	Part No	Item Description	Cust Part
2.000	DAA-2-3	125" MILL 6061 T6	D2963125

Gross Weight	51 KGS		
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Net Qty	44 KG	14 PC	44 M	1 PKG
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Specification	Dis Desc
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AMS-QQ-A-200/8 & ASTM B221-00

Mechanical Tests:

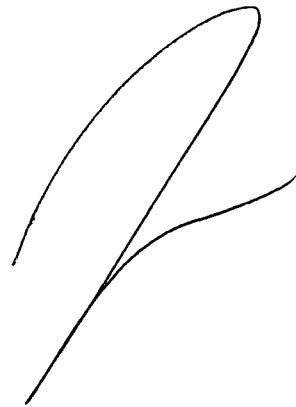
Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	308.3 / 44.7	287.6 / 41.7	10.6	.0	92

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.68	.25	.25	.07	.90	.06	.000	.07	.000	.009	.01	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Ritchie Bisnauth, QA Manager Signed for Bon L Canada



Date: Tuesday, 5/9/2006 9:13:25 AM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01	Drawing Name	: SKIDTUBE EC135 PROTOTYPE
Job Number	: 022A		
Estimate Number	: 10068		
P.O. Number	:	Part Number	: INITIAL PROTOTYPE
This Issue	: 5/9/2006	Drawing Number	: P601-637
Prsht Rev.	: NC	Project Number	: P601-637
First Issue	: 1/1	Drawing Revision	:
Previous Run	: 020A	Material	:
Written By	:	Due Date	: 2/1/2006
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: Project #:		
	: Description:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

MFG ENGINEERING

MFG ENGINEERING



Comment: MFG ENGINEERING

Manufacture Prototype as per Dwg's Supplied By Engineering

Comments:

Issue P/O 1200
To BAW L

REFERENCE ONLY

2.0

D2962150

3.540 Outer Tube, Extrut



Comment: Qty.: 10.0000 (s)/Unit Total: 10.0000 (s)
3.540 Outer Tube, Extrut

2046/15 (13)

Tuesday, 5/9/2006 9:13:25 AM
Linda Lacelle

Process Sheet

Customer: CC-DAR01

Drawing Name: SKIDTUBE EC135 PROTOTYPE

Job Number: 022A

Part Number: INITIAL PROTOTYPE

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

D2963125

105 I Beam Extrusion



Comment: Qty.: 10.0000 (s)/Unit Total: 10.0000 (s)
105 I Beam Extrusion

PU 6/6/15 (14)

Job Completion



QC 5/6 Inspect

26.06.28

B/14

REFERENCE ONLY